

**Work Order ID 64448**

December 20, 2010 8:32:27 AM



Page 1

Item ID: D2739

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 I Beam

Start Date: 12/06/10 Start Qty: 10.00



Cust Item ID:

Required Date: 12/13/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: CSDate: 10/12/10

Tooling:

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.  
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739.  
3-Use uni-bit to open holes to finish size as per Dwg D2739.  
4-Bevel Fwd end of extrusion and Deburr holes and ends.  
5-Deburr

10 0 BE 10/12/20

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 0 BE 10/12/20

**Work Order ID 64448**

Monday, December 06, 2010 10:20:17 AM

Page 2

Item ID: D2739

Accept

Revision ID:

Item Name: 350 I Beam

Start Date: 12/6/2010

Start Qty: 4.00

Required Date: 12/13/2010

Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: mfDate: 10-12-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 46

0.00

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/21 mf  
10-12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, December 06, 2010 10:20:21 AM

Page 1

Work Order ID: 64448



Parent Item: D2739

Parent Item Name: 350 I Beam


Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: C 02.11.28 Reformat KJ  
IPP Rev: D 06-03-21 As Per Rev C JLM  
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F  
10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108  Extrusion 'I Beam' thin		Manufactured	No			100	Each	131.0000	1	4			

Location

Loc Qty

Loc Code

LG

131

47814

131

10

BE 12/6/20

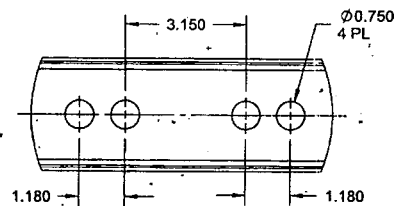
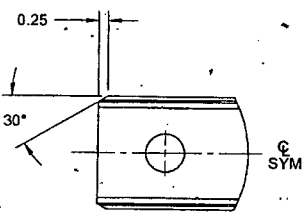
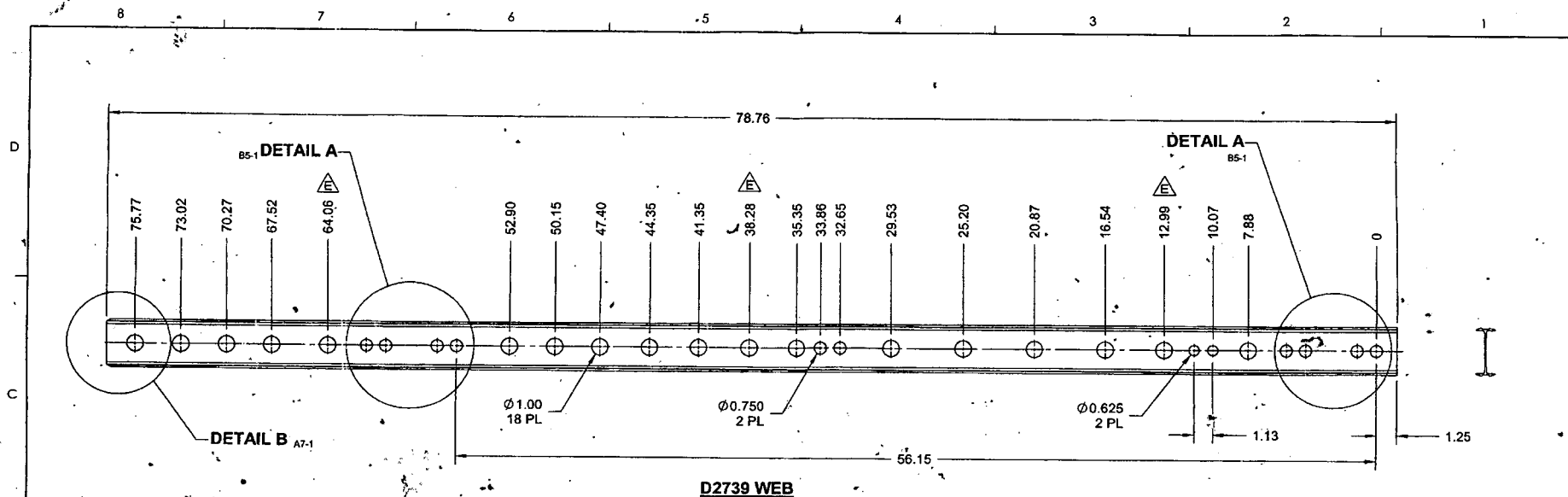
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
  - 7) WEIGHT: 3.41 lbs

RELEASED  
R 2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 84.06 WAS 84.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.10.08		

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D2739** REV. E  
SHEET 1 OF 1  
TITLE **WEB** SCALE NTS

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